



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5737-1
Job Sheet 203346

Accounting Job RD19-1069-01



Part No: D5737-1

Job Qty: 1 pcs

Part Name: FWD Weaplate



Part Weight: 0 lbs

Status: New

Job Created: 11/15/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: R+D

Description:

Note: URF 19-1208 DWG D5737 Rev.A IPP Rev. A 19.11.11 New issue DP Verify DD

Ship Via:

POSITIVE RECALLEFFECTIVE 19/11/19 AUTH. *me*RELEASED 9-89 DATE 19.11.26
9-89 Priority: Medium**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1 pcs		11/29/19	0.17	0.25	Waterjet - Flow		JRB 11/20/19
110	QC 2	1 pcs		11/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S233285



Part: D5737-1

Job No: 203346

Serial No/Batch: S233285

Revision: U/R Rev A

Inspector:

Exp Date:

Instructions:

Date: 11/20/19

Plex 11/15/19 11:09 AM Dart.lajeunesse.marie

11/15/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

120 QC 8	1 pcs	11/29/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	SRB 11/20/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	DAS 40
				QC 8 - 40	NOV 20 2019 9-89
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
130 Small Fab - Brake NC - B4B	1 pcs	11/29/19	0.25 0.17	Small Fab - Brake - 1 - B4B	DAS 30
				Small Fab - Brake - 2 - B4B	NOV 25 2019 9-89
				Small Fab - Brake - 3 - B4B	
140 QC 5	1 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS 40
				QC 5 - 61	NOV 25 2019 9-89
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	1 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	EL
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	1	11/29/19	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 53	0-53

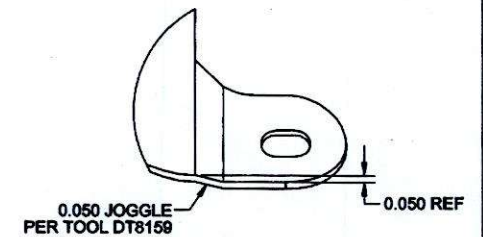
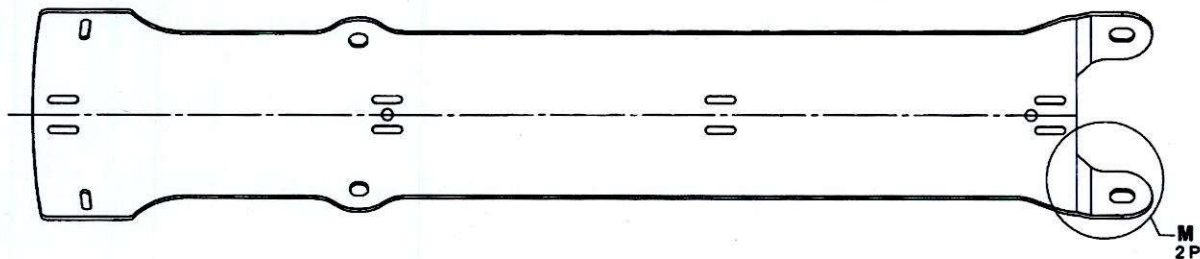
Part Op **100** - 1-Cut DSK194-1F as per dwg prog rev: A dwg rev: A 2-Debur if required
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Form as per dwg D5737
140 - QC5- Inspect part completeness to step on W/O
150 - Identify as per dwg & Stock Location: WAGD
160 - QC21- Final Inspection - Work Order Release

NOV 27 2019

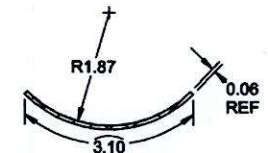
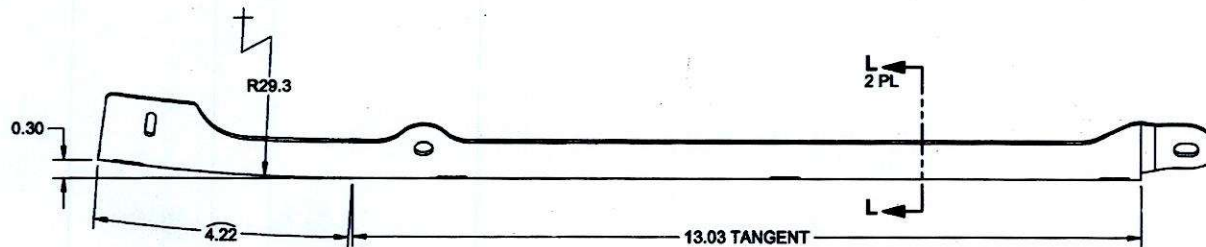
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5500 sf (.55 ea)	100-Waterjet - Flow - 1	S20758

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	266	0

Part Specifications	
Specifications could not be found.	



DETAIL M



SECTION L-L

D5737-1 FWD WEARPLATE

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 203346 ML5
1911-15

UNDER REVIEW

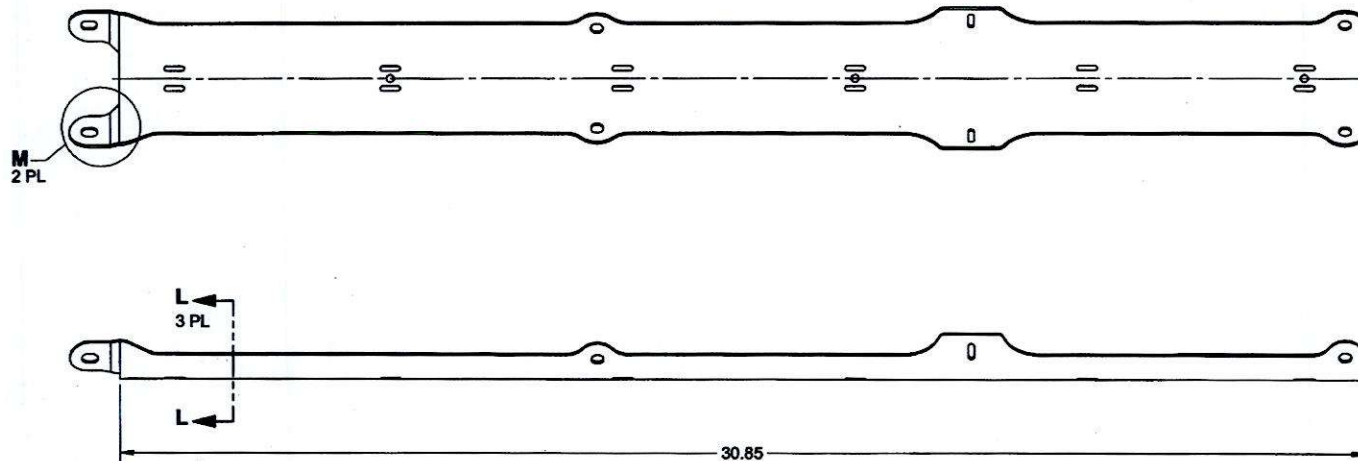
URF 19-1208 19.11.07 (VM)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) THICK
PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DSK194-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.02 lbs

APPROVED

DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5737	SHEET 7 OF 9
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	TRAINING WEARPLATES	NTS
DATE	19.08.22	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D5737-5 AFT WEARPLATE

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WITHOUT NOTICE
WORK ORDER
NO. _____

UNDER REVIEW

URF 19-1208 19.11.07 (VM)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 18 GAUGE (0.063) THICK
PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
REF DSK194-5F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.78 lbs

APPROVED

DESIGN	ZF	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	ZF		
CHECKED	MW	DRAWING NO.	REV. A
MFG. APPR.	DD	D5737	SHEET 8 OF 9
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	TRAINING WEARPLATES	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: FWD wearplate		Part Number:	DSK194-1
Inspection Dwg: DSK194	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.48	+/- 0.030	1.48				
R1.00	+/- 0.030	R1.00				
0.15	+/- 0.030	0.15				
R0.08	+/- 0.030	R0.08				
0.50	+/- 0.030	0.50				
R0.13	+/- 0.030	R0.13				
0.300	+/- 0.010	0.303				
R0.13	+/- 0.030	R0.13				
0.300	+/- 0.010	0.302				
R0.50	+/- 0.030	R0.50				
0.50	+/- 0.030	0.52				
0.13	+/- 0.030	0.13				
R0.06	+/- 0.030	R0.06				
0.38	+/- 0.030	0.36				
0.19	+/- 0.030	0.20				
R0.50	+/- 0.030	R0.50				
0.400	+/- 0.010	0.404				
0.300	+/- 0.010	0.301				
1.000	+/- 0.010	1.000				
R0.13	+/- 0.030	R0.13				
1.25	+/- 0.030	1.26				
4.25	+/- 0.030	4.25				
2.75	+/- 0.030	2.77				
2.13	+/- 0.030	2.14				
1.38	+/- 0.030	1.35				
5.250	+/- 0.010	5.250				
2.410	+/- 0.010	2.412				
1.205	+/- 0.010	1.206				
3.710	+/- 0.010	3.710				

Measured by:		Checked by:		QC Inspector:	
Date:		Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.855	+/-0.010	1.856			JRB-01V	
12.550	+/-0.010	12.552			JRB-02V	
3.00	+/-0.030	3.05			Tape	
1.50	+/-0.030	1.49				
1.263	+/-0.010	1.262				
1.91	+/-0.010	1.92				
2.526	+/-0.010	2.526				
3.83	+/-0.030	3.83				
18.500	+/-0.010	18.500				
17.25	+/-0.030	17.25				
16.56	+/-0.030	16.56				
16.50	+/-0.030	16.50				
0.188	+/-0.005 +10.005 -p.001	0.191				
11.13	+/-0.030	11.15				
5.88	+/-0.030	5.83				
5.83	+/-0.030	5.82				
0.73	+/-0.030	0.73				
0.25	+/-0.030	0.26				

Measured by: JRB	Checked by:	QC Inspector:
Date: 11/20/19	Date:	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	